

Date: Wednesday, 22/10/2008 1:31:50 PM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : EYEBALL ADAPTER |
| Job Number : 42819 | |
| Estimate Number : 12246 | |
| P.O. Number : | |
| This Issue : 22/10/2008 S.O. No. : | Part Number : D3480041 |
| Prsht Rev. : NC | Drawing Number : D3480 UNDER REVIEW |
| First Issue : / / Type : SMALL /MED FAB | Project Number : N/A |
| Previous Run : 34469 | Drawing Revision : B |
| Written By : | Material : |
| Checked & Approved By : <u>JUD 08-10-22</u> | Due Date : 08/11/2008 Qty: 2 Um: Each |
| Comment : est rev. A 06.02.07 new issue EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|------------------------|
| 1.0 | D34805 | Eyeball Adapter Flange |
|-----|--------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part number | Description | Batch |
| 1 | D3480-5 | Flange | B28 809 |

| | | |
|-----|--------|------|
| 2.0 | D34803 | Tube |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part number | Description | Batch |
| 1 | D3480-3 | Tube | B28 575 |

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

FF 09/01/21

(2)

| | | |
|-----|------|-----------------------------------|
| 4.0 | QC11 | VISUAL INSPECTION OF SPOT WELDING |
|-----|------|-----------------------------------|



Comment: VISUAL INSPECTION OF SPOT WELDING

JB 09/01/21

(2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 1:31:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 42819

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/01/21

(2)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 164

9/1/24

(22)

20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/23

Job Completion



MF 09-01-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

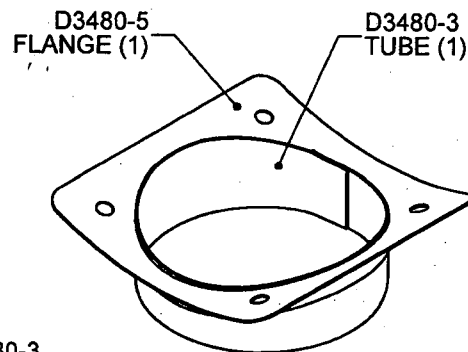
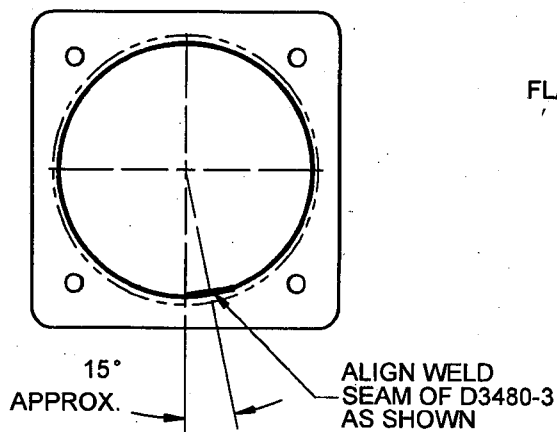
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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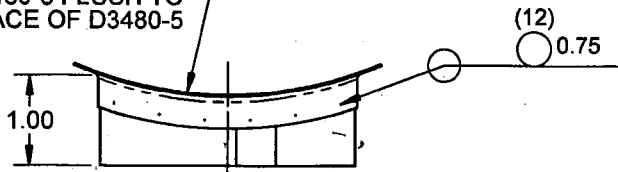
NOTE: Date & initial all entries

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| CHECKED <i>PH</i> | APPROVED <i>PH</i> | DRAWING NO. D3480 | REV. B SHEET 1 OF 6 |
| DATE 06.08.29 | | TITLE EYEBALL ADAPTER | SCALE 1:2 |
| A | 06.02.06 | NEW ISSUE | |
| B | 06.08.29 | D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330 | |



SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5

**UNDER REVIEW**

07.06.09
Dirt + Manufacturing
(White)

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06.09.19
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D3480-041 EYEBALL INLET ADAPTER**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|-----------------------|
| X | D3480-041 | EYEBALL INLET ADAPTER |
| 1 | D3480-3 | TUBE |
| 1 | D3480-5 | FLANGE |

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| DATE 06.08.29 | | TITLE EYEBALL ADAPTER SCALE 1:1 | |

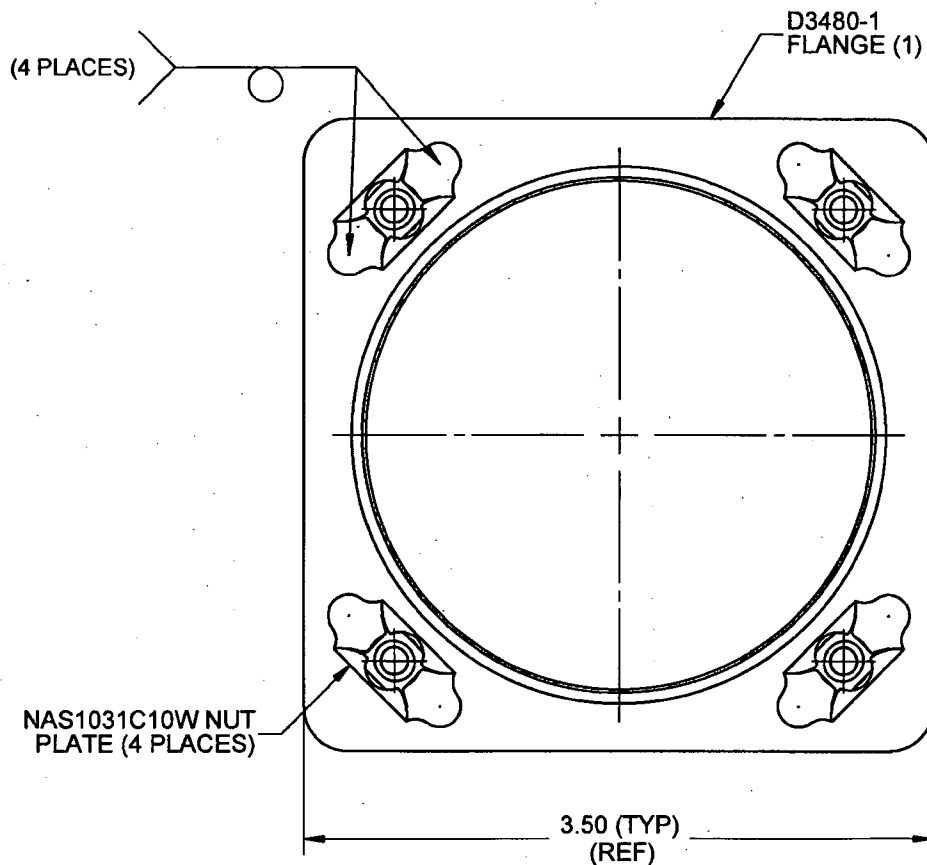
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UNDER REVIEW

07.06.03 *[Signature]*

Dist. + Manufacturing
Checked



D3480-043 EYEBALL ADAPTER

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NO. 42819

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

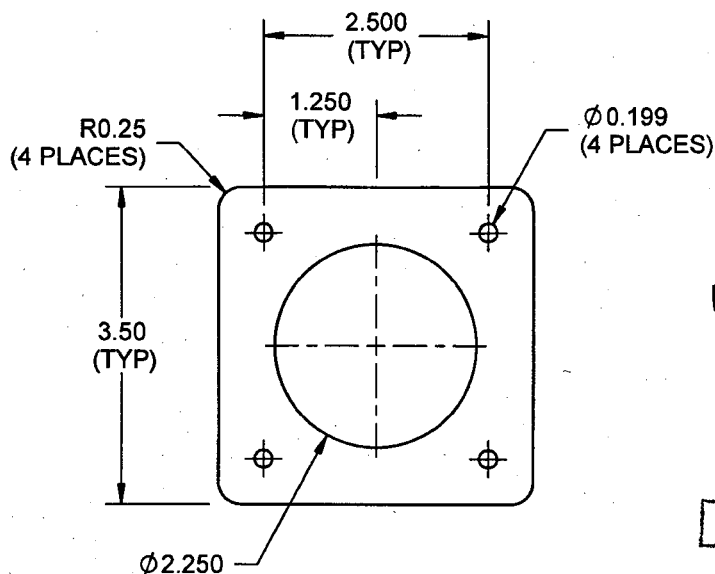
| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|-----------------|
| X | D3480-043 | EYEBALL ADAPTER |
| 1 | D3480-1 | FLANGE |
| 4 | NAS1031C3W | NUTPLATE |

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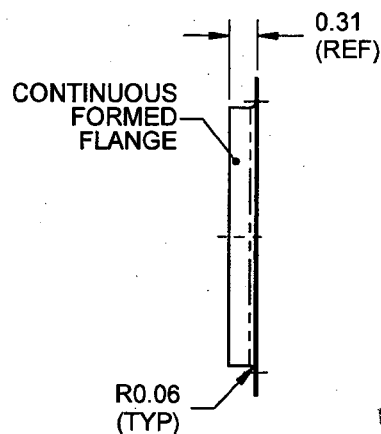
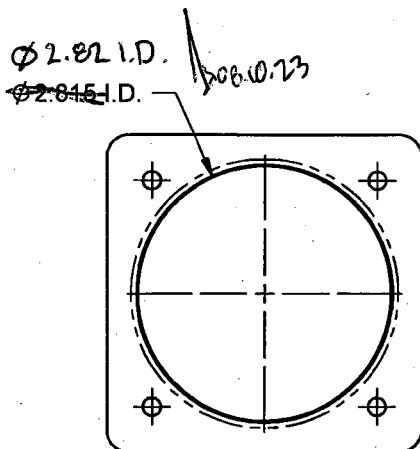
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| DATE 06.08.29 | | TITLE EYEBALL ADAPTER | SCALE 1:2 |

**UNDER REVIEW**

07.06.07 *[Signature]*
Dirt + Manufacturing
Change

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06.09.19 *[Signature]*

D3480-1F FLAT PATTERN**D3480-1 FLANGE
(MAKE FROM D3480-1F)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

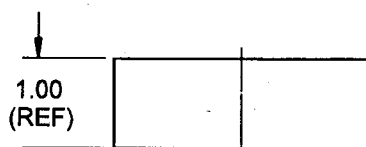
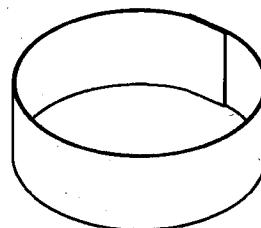
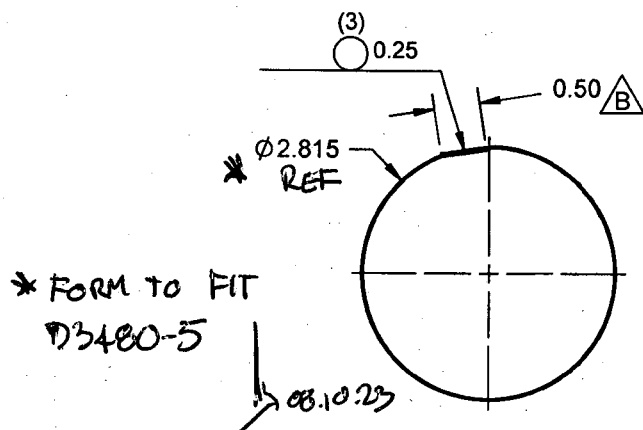
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| DATE 06.08.29 | | TITLE EYEBALL ADAPTER | SCALE 1:2 |



D3480-3 TUBE

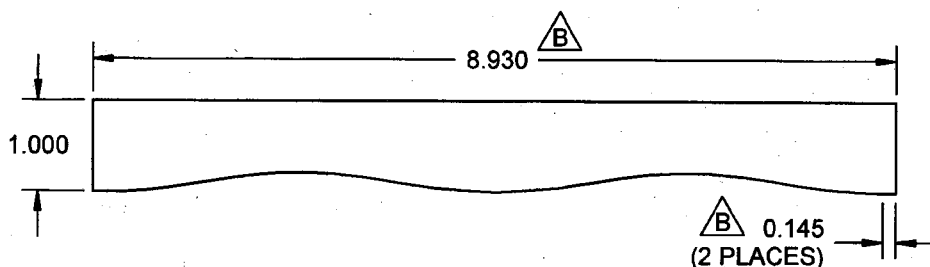
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Dim + Manufacturing
Checks



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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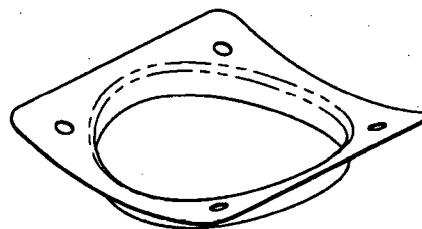
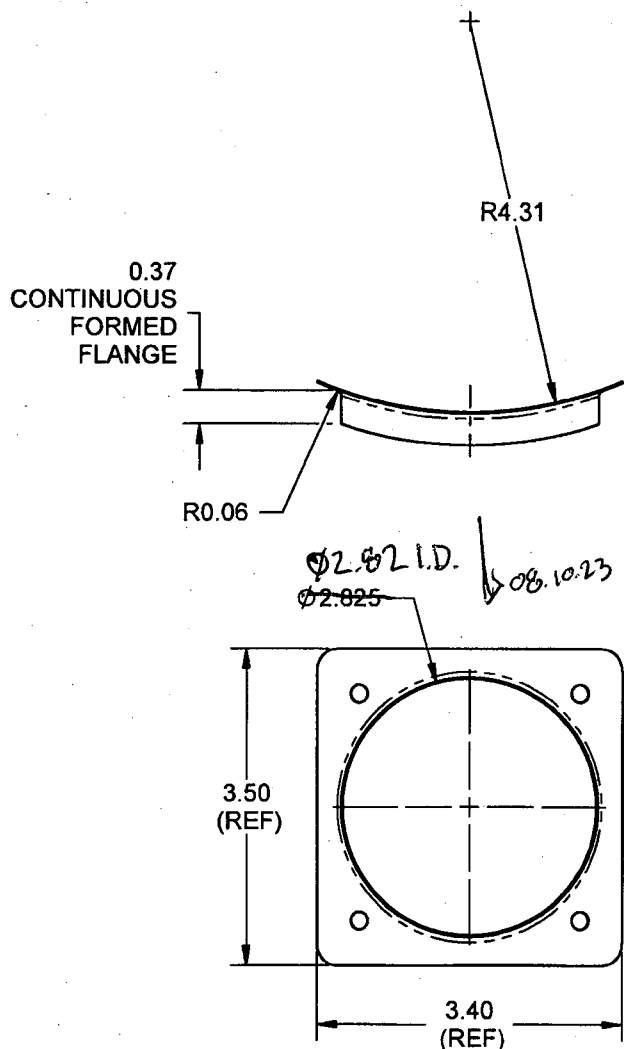
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| DATE 06.08.29 | | TITLE EYEBALL ADAPTER | SCALE 1:2 |



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UNDER REVIEW

02.09.22 *[Signature]*

Dim + Manufacturing
Checks

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

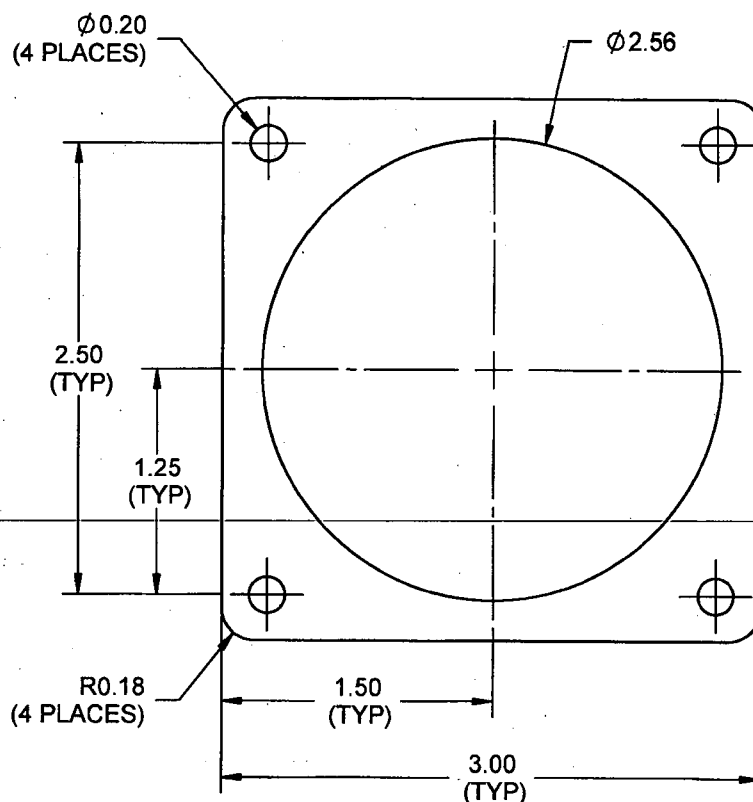
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| DATE 06.08.29 | | TITLE EYEBALL ADAPTER | SCALE 1:1 |



UNDER REVIEW

02.09.2013
Dir + Manufacturing
(init)

RELEASED

06.09.19

D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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